

Work Order ID 165299

Monday, August 21, 2017 9:43:38 AM

Page 1

Item ID: 647.1404

Revision ID:

Item Name: Upper Cutter Assembly

Start Date: 8/21/2017 Start Qty: 1.00

Required Date: 8/24/2017 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.1400	C

110	Pick Kit	0.00
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110

Packaging

Memo

Packaging

0.00

1	Ø	AUG 21 2017	DAS 19 9-00
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120		0.00
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120

Small Fab

Memo

Small Fab

0.54

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: 137797
exp. date: 04/19

1	Ø	AUG 21 2017	DAS 19 9-00
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130	QC5- Inspect part completeness to step on W/O	0.00
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130

QC

Memo

Quality Control

0.02

1	Ø	AUG 22 2017	DAS 38 9-00
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Work Order ID 165299

Monday, August 21, 2017 9:43:38 AM

165299

Page 2

Item ID: 647.1404 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Cutter Assembly
Start Date: 8/21/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/24/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Packaging Packaging	Identify as per dwg & Stock Location CK048 Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***	0.00 0.01				<u>1</u>	<u>AUG 22 2017</u>	<u>6</u>	DAS 6 9-89
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.10					DAS 21 9-89	<u>AUG 22 2017</u>	

WM 17/8/22 **DAS**
21
9-89

Picklist Print

Monday, August 21, 2017 9:43:36 AM

Page 1

Work Order ID: 165299

165299

Parent Item: 647.1404

647 1404

Parent Item Name: Upper Cutter Assembly

Start Date: 8/21/2017

Required Date: 8/24/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.03.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149FN832P		Purchased	No			110	Each	856.0000	6	6			
NAS1149FN832P									**			AUG 21 2017	DAS 19 9-99
Washer													

Location

Loc Qty

Loc Code

GA

591

M135058

208

M136182

40

M136866

43

M137820

300

ST263

265

M137820

265

MS27039-08-19

Purchased

No

110

Each

161.0000

3

3

MS27039-08-19

**

AUG 21 2017

DAS
19
9-99

Screw

Location

Loc Qty

Loc Code

GA

30

m135948

26

m137178

4

ST277

131

m137464

11

m138045

1

m138237

19

m138237

100

Picklist Print

Monday, August 21, 2017 9:43:36 AM

Page 2

Work Order ID: 165299

165299

Parent Item: 647.1404

647 1404

Parent Item Name: Upper Cutter Assembly

Start Date: 8/21/2017

Required Date: 8/24/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

110

Each

408.0000

3

3

MS21042L 08

Nut

**

AUG 21 2017

DAS

19

9-99

Location

Loc Qty

Loc Code

GA

94

m135978

94

ST303

314

m138207

125

m138237

189

3

646.9703

Manufactured

No

110

Each

2.0000

1

1

646 9703

Cutter Sub Assembly

**

AUG 21 2017

DAS

19

9-99

Location

Loc Qty

Loc Code

CCK013

2

154457

2

1

647.1513

Manufactured

No

110

Each

1.0000

1

1

647 1513

Upper Deflector

**

AUG 21 2017

DAS

19

9-99

Location

Loc Qty

Loc Code

CCK015

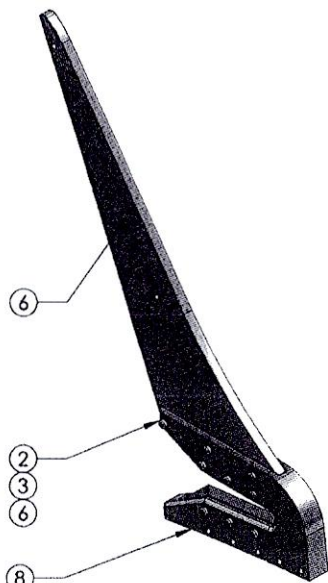
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153551

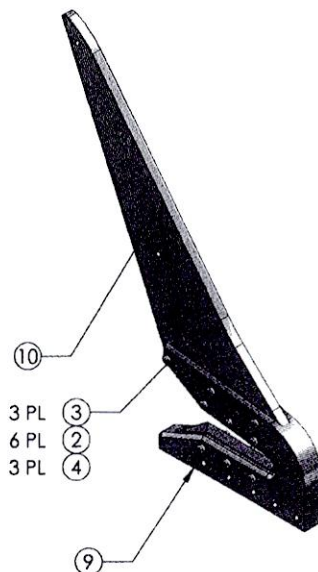
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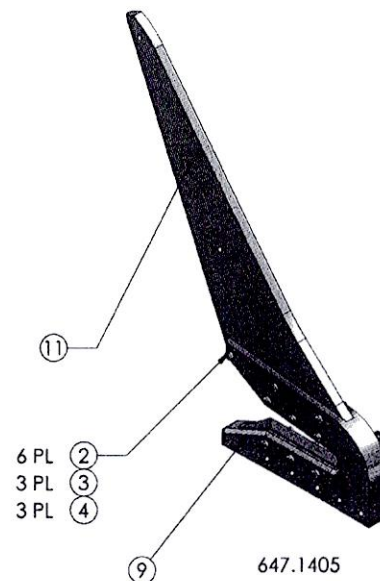
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647.1403



647.1404



647.1405

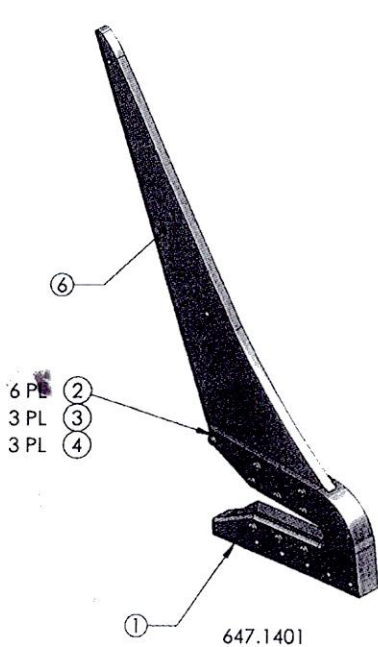
ORIGINAL DATE 06-15-09		3030 ENTERPRISE CT., SUITE A	
DRAWN BY J. CARDNER	CHECKER P. BRAVO	VISTA, CA. 92081	
DRAWING APPROVAL P. BRAVO 06-15-09		APICAL INDUSTRIES INC. DBA DART AEROSPACE	
CONTRACT NO.		760-724-5300	
CUTTER ASSY			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ± .01 2 PLACE DECIMALS ± .005 ANGLES ± .5°	SHEET B	CAGE CODE 07M26	DWG. NO. 647.1400
	SCALE NONE		REV. C
			SHEET 2 OF 2

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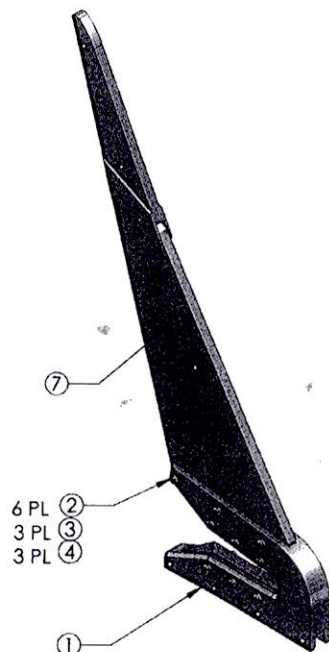
NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 6, & 7 UPON ASSEMBLY

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PRI		N/C
N/C	INITIAL RELEASE	06/15/09	P. BRAVO
A	INCORPORATED ECN'S 02962 & 03911	06/07/13	P. BRAVO
B	INCORPORATED ECN 05330	02/28/16	P. BRAVO
C	INCORPORATED ECN 05549	11/01/16	P. BRAVO



647.1401



647.1402

1	-	-	-	-	11	647.1514	UPPER DEFLECTOR		
-	1	-	-	-	10	647.1513	UPPER DEFLECTOR		
1	1	-	-	1	9	646.9703	CUTTER SUB ASSY		
-	-	1	-	-	8	646.9702	CUTTER SUB ASSY		
-	-	-	1	-	7	647.1501			
-	-	1	-	1	6	647.1510	UPPER DEFLECTOR		
A/R	A/R	A/R	A/R	A/R	5	601.2045	RTV, LOCTITE 598		
3	3	3	3	3	4	601.1541	LOCKNUT	MS21042L08	
3	3	3	3	3	3	601.2765	SCREW	MS27039-Q819	
6	6	6	6	6	2	601.2764	WASHER	NAS1149FN832P	
-	-	-	1	-	1	646.9701	CUTTER SUB ASSY		
X						647.1405	CUTTER ASSY (UPPER)		
	X					647.1404	CUTTER ASSY (UPPER)		
		X				647.1403	CUTTER ASSY (UPPER)		
			X			647.1402	CUTTER ASSY (LOWER)		
				X		647.1401	CUTTER ASSY (UPPER)		
.1405	.1404	.1403	.1402	.1401	FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY		PARTS LIST	
NEXT ASSY (S)		ORIGINAL DATE	06-15-09
647.1300		DRAWN BY	CHECKER
		1. DRAWN BY	P. BRAVO
		2. DRAWING APPROVAL	
		3. BRAVO	
		CONTRACT NO.	
		UNLESS OTHERWISE SPECIFIED	
		DIMENSIONS ARE IN INCHES	
		TOLERANCES ARE:	
		1. PLACE DECIMALS ±.01	
		2. PLACE DECIMALS ±.005	
		ANGLES ±.5°	
SIZE	CAGE CODE	DWG. NO.	REV.
B	07M26	647.1400	C
SCALE: NONE		SHEET 1 OF 2	

DART AEROSPACE
3030 ENTERPRISE CT., SUITE A
VISTA, CA 92081
(760)-724-5300
APICAL INDUSTRIES INC.
DBA DART AEROSPACE

CUTTER ASSY